

Abstract

An on-line roll grinding method for a work roll, which can decrease an overshoot, by which the pressing load of a rotating grinding wheel on a work roll exceeds a set grinding pressing load, is provided. This method is an on-line grinding method for a work roll, adapted to press a rotating grinding wheel (3a) having elasticity against a work roll (1) of a rolling mill to grind the work roll, wherein when the pressing load of the rotating grinding wheel (3a) reaches a set load F , which has been set beforehand, after the rotating grinding wheel (3a) contacts the work roll (1), the forward velocity of the rotating grinding wheel (3a) is reduced to decrease an overshoot by which the pressing load of the rotating grinding wheel (3a) on the work roll (1) exceeds a set grinding pressing load F_0 .